

TABLE 3

Formula for Black RTD Coffee Final Product with Added Flavor	
Ingredient	Kgs/15 Kg
Sucrose	0.450000
Coffee Extract	8.628000
Buffer	0.022500
Flavor (Furfurylthiol)	0.000044
Ethanol	0.004356
Water	5.895100
TOTAL	15.000000

[0046] The Black RTD Coffee Final Products and controls are stored at  $-40^{\circ}\text{C.}$ ,  $38^{\circ}\text{C.}$  and  $60^{\circ}\text{C.}$

## Example 2

## Milk Based RTD Coffee

[0047] Arabica coffee extract is prepared as described in Example 1.

[0048] (a) Preparation of Milk Base Solution Having the Formula Shown in Table 4:

[0049] (1) predissolving stabilizer in water using high shear mixing;

[0050] (2) adding the predissolved stabilizer to heated milk and cream with mixing;

[0051] (3) homogenizing; and

[0052] (4) storing in canister under nitrogen gas protection.

TABLE 4

Formula for Milk base	
Ingredient	Kgs/100 Kg
Heavy Cream	3.758
Fluid Milk(Whole)	79.253
Stabilizer	0.989
Water	16.000
Total	100.000

[0053] (b) Preparation of Milk RTD Coffee Final Product Having the Formula Shown in Table 5:

[0054] (1) Combining sugar and buffer in nitrogen protected atmosphere with mixing;

[0055] (2) adding nitrogen protected coffee extract from canister to above with mixing;

[0056] (3) adding milk base from canister with mixing;

[0057] (4) adding flavor precursor (furfurylthioacetate, supplied at 1% in ethanol) or flavor (furfurylthiol, supplied at 1% in ethanol) with mixing; and

[0058] (5) filling into steel cans with nitrogen gas headspace, seaming and retorting at  $F_0=35$ .

TABLE 5

Formula for Milk RTD Coffee Final product with added Precursor	
Ingredient	Kgs/15 Kg
Sucrose	0.78000
Coffee Extract	11.25000
Milk Base	2.63100
Buffer	0.02250
Flavor Precursor (FFT-Ac)	0.00006

TABLE 5-continued

Formula for Milk RTD Coffee Final product with added Precursor	
Ingredient	Kgs/15 Kg
Ethanol	0.00594
Water	0.31050
TOTAL	15.00000

TABLE 6

Formula for Milk RTD Coffee Final product with added Flavor	
Ingredient	Kgs/15 Kg
Sucrose	0.78000
Coffee Extract	11.25000
Milk Base	2.63100
Buffer	0.02250
Flavor (furfurylthiol)	0.00006
Ethanol	0.00594
Water	0.31050
TOTAL	15.00000

[0059] Control Milk RTD Coffee Final Product is prepared by omitting flavor precursor or flavor (see Formula in Table 7).

TABLE 7

Formula for Control Milk RTD Coffee Final product	
Ingredient	Kgs/15 Kg
Sucrose	0.7800
Coffee Extract	11.2500
Milk Base	2.6310
Buffer	0.0225
Ethanol	0.0060
Water	0.3105
TOTAL	15.0000

Results of the sensory analysis and chemical analysis are as follows:

## Sensory Analysis

[0060] 12 panelists who are experienced in assessing taste differences in coffee products evaluated and compared the previous samples. Each stored sample was compared to the frozen reference ( $-40^{\circ}\text{C.}$  furfurylthioacetate sample) and scored on a scale of  $-5$  to  $+5$  with the frozen reference being 0.

Results are as follows for the black products:

	Acidic/Sour Flavor	Roasty Flavor
REF = 2237.02 w FFT Acetate Black 4 wks $-40^{\circ}\text{C.}$	0	0
Sample 2 = 2237.01 Control Black 4 wks $60^{\circ}\text{C.}$	0.67	-0.67
Sample 3 = 2237.02 w FFT Acetate Black 4 wks $60^{\circ}\text{C.}$	0.36	-0.61
Sample 4 = 2237.03 w Furfurylthiol Black 4 wks $60^{\circ}\text{C.}$	0.59	-1.1